

Date: Thursday, 28/05/2009 9:11:27 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BASKET HINGE		
Job Number	: 48230			Part Number	: D22321		
Estimate Number	: 10587			Drawing Number	: D2232 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	28/05/2009	S.O. No.	:	Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	11	Type	SMALL /MED FAB	Due Date	12/06/2009	Qty:	12
Previous Run	: 46709			Um:	Each		
Written By	:						
Checked & Approved By	: <u>JUL 09-05 28</u>						
Comment	: Est.B 01.06.07 Now laser cut EC						
	Est Rev:C Now on Waterjet 06-11-21 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 0.125 Sheet
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Comment: Qty.:	0.0255 sf(s)/Unit	Total :	0.3062 sf(s)
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304/316 .125 Sheet	<u>11018 BR 9-6-3</u>
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2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2232

Dwg Rev: <u>C</u>

Prog Rev: <u>C</u>

<u>BR 9-6-3</u>

2-Deburr if necessary

<u>M-1</u>

<u>09/06/03</u>

<u>Q0X</u>

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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<u>BR 9-6-3</u>

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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<u>S 09/06/04</u>	<u>counts</u>
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Comment: SECOND CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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<u>2dc</u>

Comment: PACKAGING RESOURCE #1

Identify and Stock Location: <u>Car</u>
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<u>9/6/11</u>

<u>SO</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 28/05/2009 9:11:28 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET HINGE

Job Number: 48230

Part Number: D22321

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



09/06/05 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-06-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	48230
Description: Basket Hinge	Part Number:	D2232-1
Inspection Dwg: D2232 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

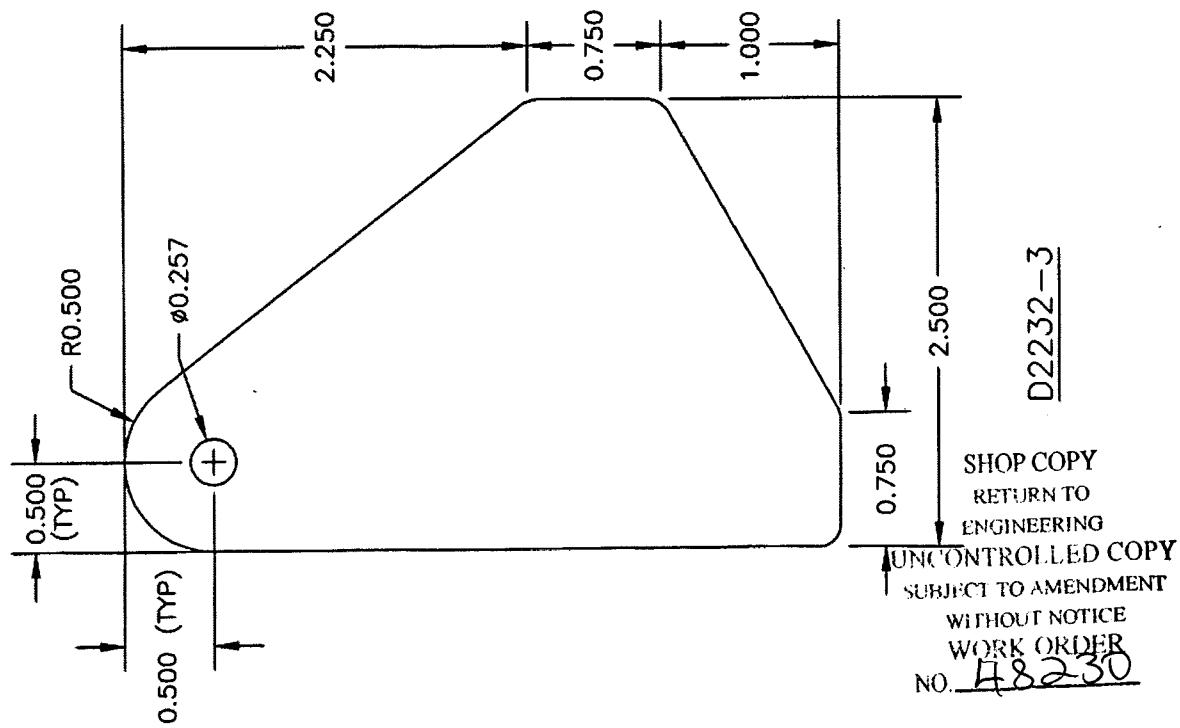
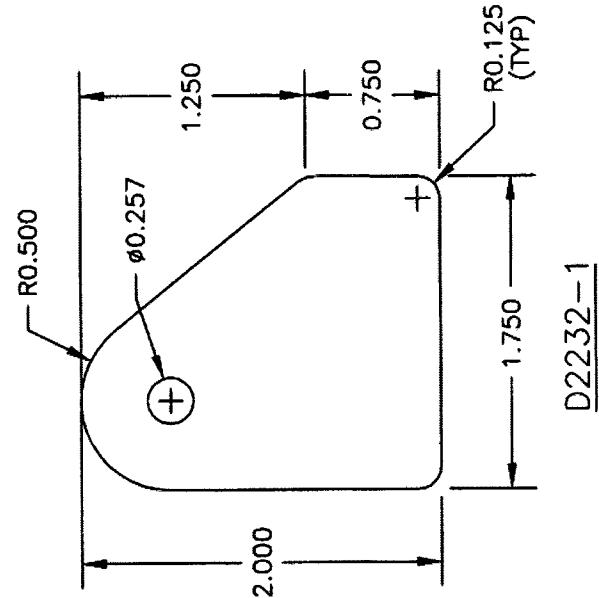
Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	9-6-3	Date:	09/06/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	E

DART

COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2232 REV. C SHEET 1 OF 2
DATE		TITLE BASKET HINGE SCALE 1:1
98.04.28		
A	94.05.12	NEW ISSUE
B	96.01.02	ADDED -5 AND -7
C	98.04.28	0.125 THICK WAS 0.063

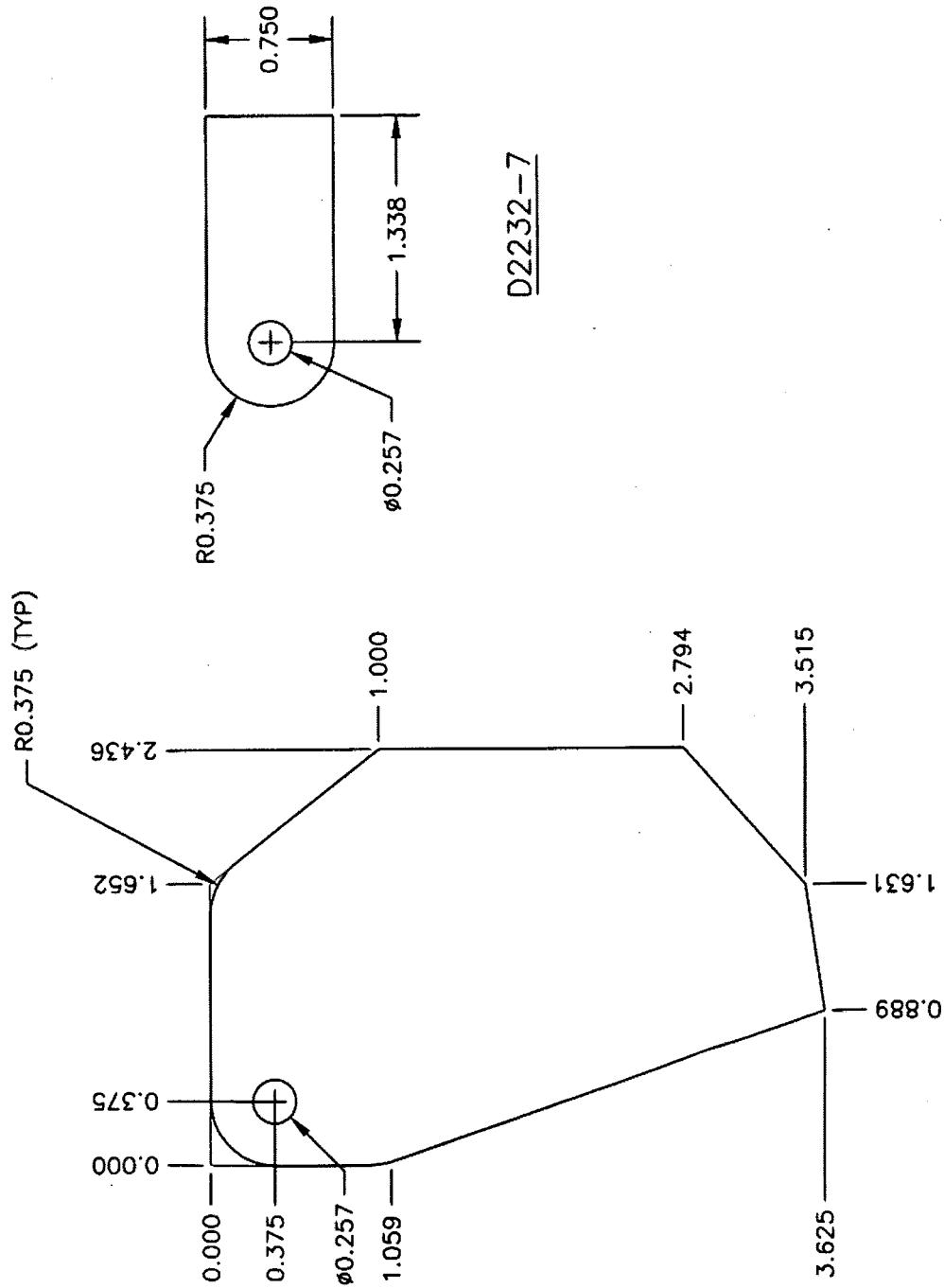
RELEASED
98-05-05 KE

MATERIAL: AISI 304/316 SS 0.125 THICK

DART

COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2232
DATE	98.04.28	REV. C SHEET 2 OF 2 TITLE BASKET HINGE SCALE 1:1

RELEASED
48.05.05 KE

MATERIAL: AISI 304/316 SS 0.125 THICK